

Date: Friday, 19/10/2007 2:56:25 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOOR PROTCTOR AFT RH		
Job Number	: 35249			Part Number	: D32814		
Estimate Number	: 11235			Drawing Number	: D3281 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 19/10/2007	S.O. No.	:	Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: 18/10/2007	Type	: THERMOFORMING	Due Date	: 25/10/2007	Qty:	<i>L</i> Um: Each
Previous Run	: 35085						
Written By	: <i>W</i>						
Checked & Approved By	: <i>W</i>						
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <i>4865</i> Description: Floor Protector Aft, RH Possible Supplier: Delastek Certificate of Conformity is required	<i>C 20/10/2007</i>
2.0	D32814P	Floor Protector, Aft RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Floor Protector Aft, RH	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached	<i>20/10/2007 (4)</i>
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.	<i>20/10/2007 (4)</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST266</i>	<i>(4) 07/10/2007 AS. W</i>

Date: Friday, 19/10/2007 2:56:25 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR AFT RH

Job Number: 35249

Part Number: D32814

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



07.10.31 JF

Comment: FINAL INSPECTION/W/O RELEASE

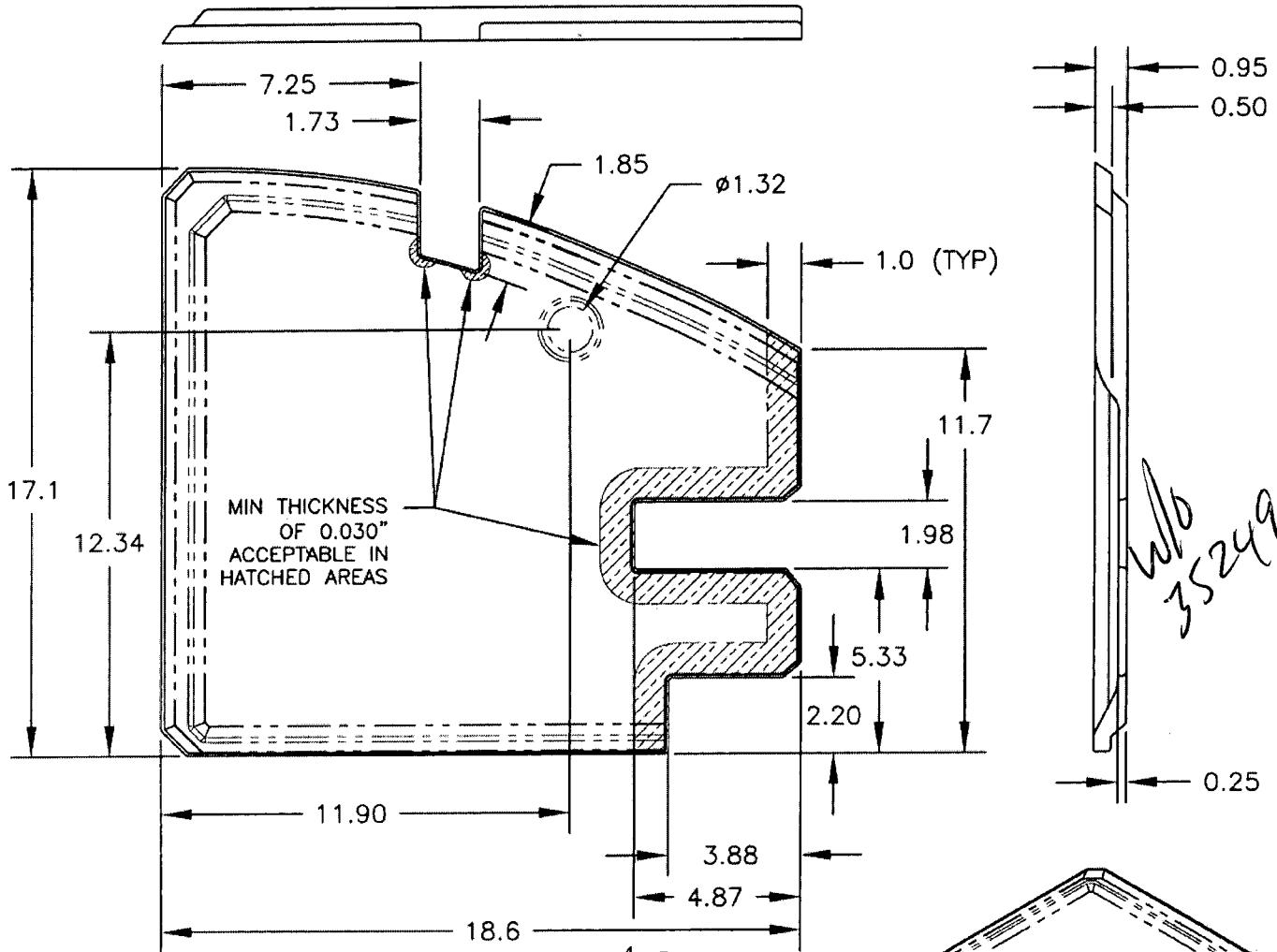
Job Completion



U 07.10.31



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3281 REV. B SHEET 1 OF 3
DATE		TITLE FLOOR PROTECTOR SCALE 1:5
05.11.25		
A	04.05.03	NEW ISSUE
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED



RELEASED
05.12.01

UNDER REVIEW

07.10.08 LE
OK TO MANUFACTURE
AND SHIP

D3281-1 FLOOR PROTECTOR, FWD LH

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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WITHOUT NOTICE

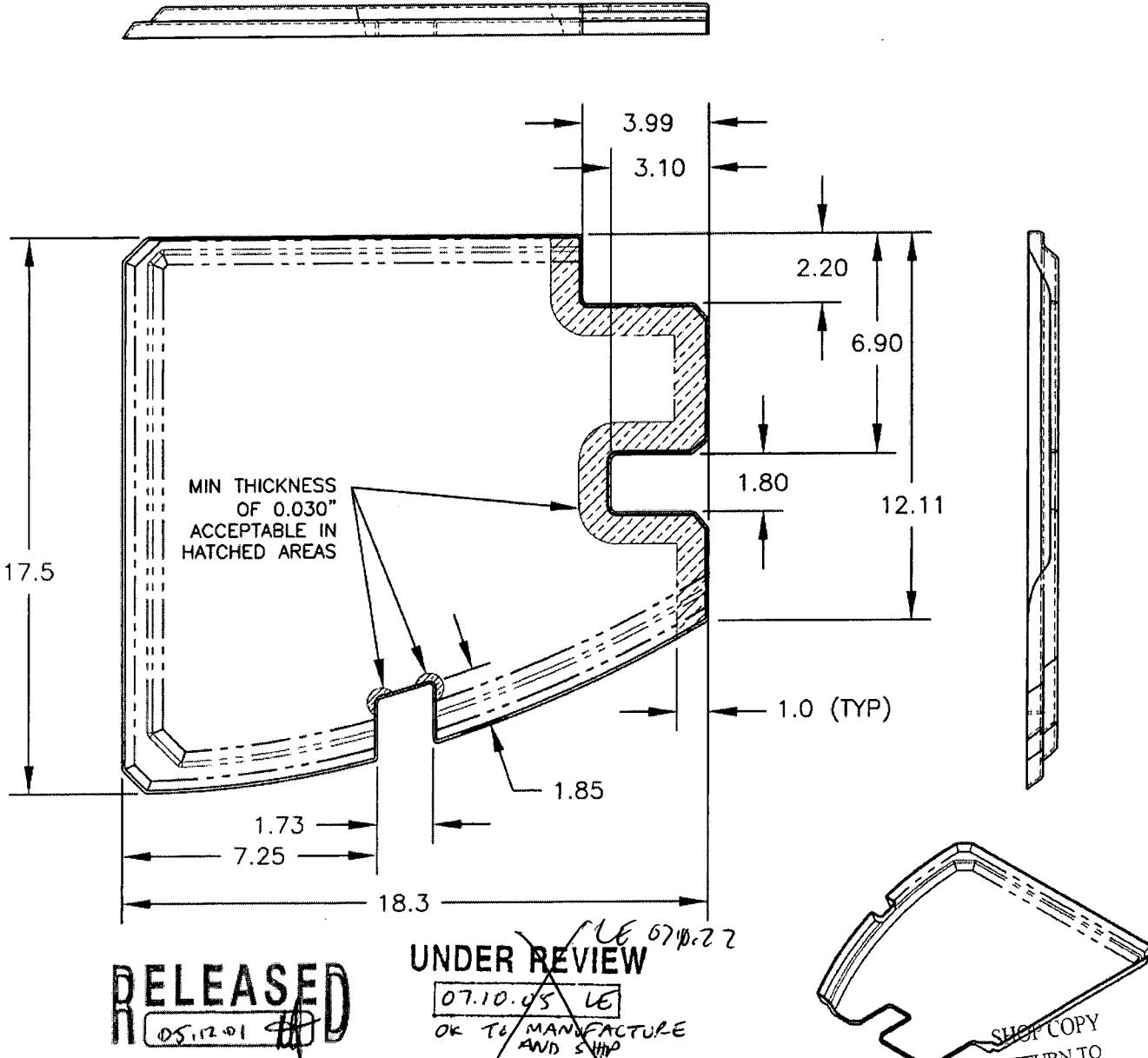
WORK ORDER
NO. 35249

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3281
DATE	TITLE	SCALE 1:5
05.11.25	FLOOR PROTECTOR	

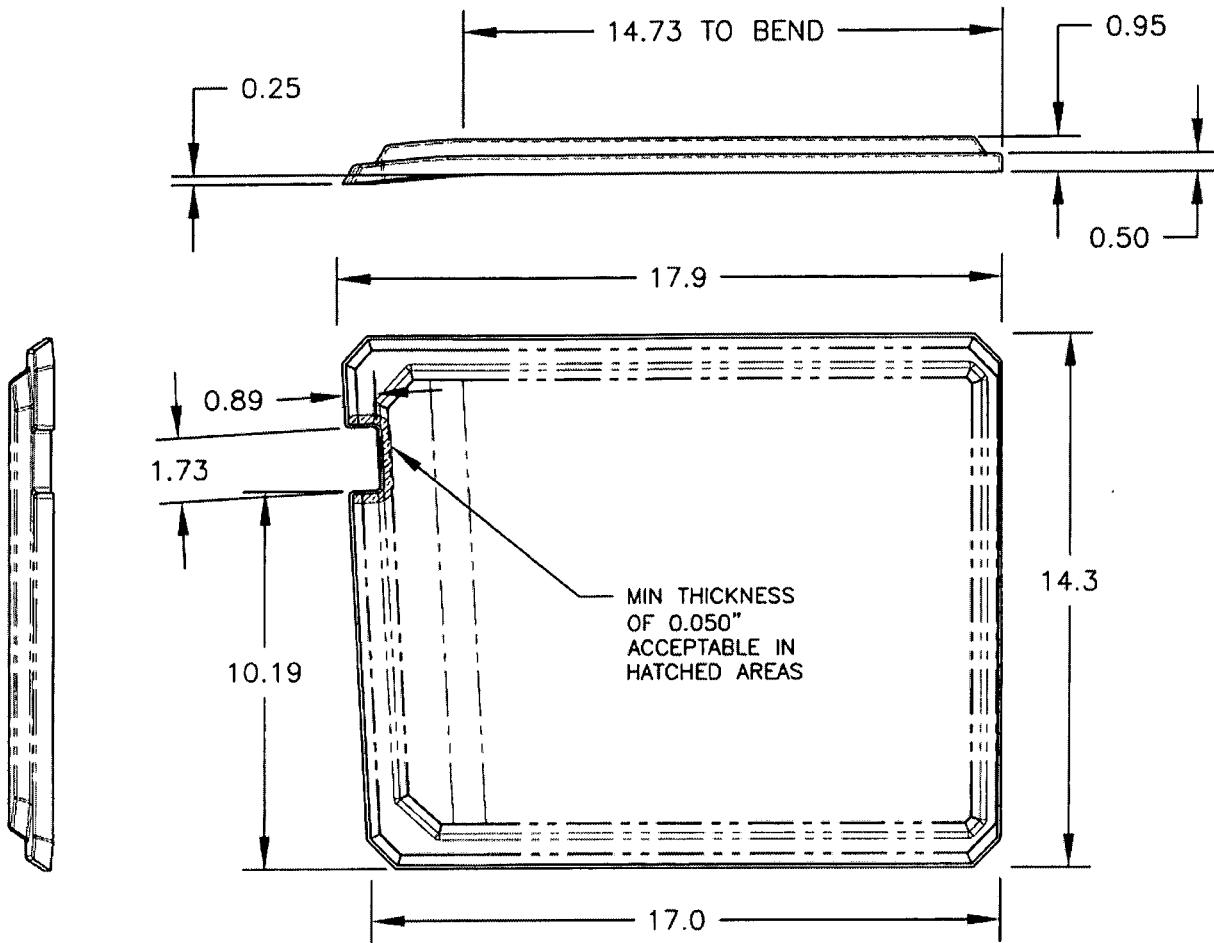


D3281-2 FLOOR PROTECTOR FWD RH

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T1
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN



DESIGN <i>OP</i>	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

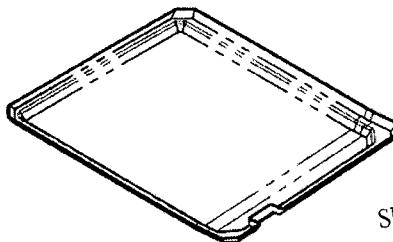


~~RELEASED~~
05.12.01. *[Signature]*

07-10-22
~~UNDER REVIEW~~

07.10.08 LE

*OK TO MANUFACTURE
AND SHIP*



D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)

D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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date: Jeudi, 2006-11-16 15:07:40
 Utilisateur: Sylvie Hamel

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : FLOOR PROTECTOR AFT, LH
Numéro Job : 40357		Numéro Article : DKC134-0047
Numéro Soumission : 2386		Numéro Dessin : D3281
Numéro B.A. :		Projet Numéro : DKC134
Cette fois : 2006-11-16	No. B.V. :	Révision dessin : B
Prst Rev. : NC		Matériel : F6006
Rem. fois :	Type :	Date Due : 2006-12-08
Job précédente : 36895		Qté: 16 Udm: UNITE
Écrit par :		
Vérifié & Approuvé par :		
Commentaires : N° de pièce: D3281-4		

Process Sheet Rév.: 00 Création du premier



Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
Commentair Qty.:	0.167 UNITE(s)/Unit Totz'	APL0016
	Lexan F6006 Noir N° 700 48" x 96"	3 - 5913-1
	N° de Lot:	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
		# Bon achat: 5913
2.0	SÉCHAGE/ ANEAL	



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.5000Hrs

SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 5484

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 45.0000Hrs

TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 25 Date: 11-16-07 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Date: Jeudi, 2006-11-16 15:07:40

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 40357

Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération:

Description :

4.0 THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs

THERMOFORMAGE DES PIECES

Faire le thermoformage du "Floor Protector" N° D3281-4 à l'aide du moule N° D3281-4T1 sur le thermoformeur 4' x 8'.

QAS
D4-14

RD

Autocontrôle du lot de pièce thermoformées.



Quantité: 24 Date: 11-1-07 Sceau:

J. Aug.

Quantité: Date: Sceau:

5.0 TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs

TRIMAGE PLASTIQUE DART

Faire le trimage du "Floor Protector" N° D3281-4 à l'aide du gabarit de trimage N° D3281-4T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 24 Date: 12-1-07 Sceau:

Quantité: Date: Sceau:

6.0 INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs

INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 24 Date: 18-01-07 Sceau:

7.0 IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs

IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Date: Jeudi, 2006-11-16 15:07:40

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 40357

Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération: Description :

N° de pièce: D3281-4

N° de Job: 40357

Date de fabrication: 15-1-07

Sceau d'inspection.

Quantité: 24 Date: 15-1-07 Sceau: LBB

Quantité: _____ Date: _____ Sceau: _____

8.0 EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boite en carton identifiée comme suit:

N° de pièce: D3281-4

Date de fabrication: _____

N° de job: _____

Quantité: 24 Date: 18/1/07 Sceau: 71

Quantité: _____ Date: _____ Sceau: _____



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice #	12223
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via	F.O.B.	Terms		Salesperson	
PURO COLLECT		Origin	Net30 days	Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #
24/10/2007	22/10/2007	5510	C. LAVOIE	PO000004865	
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description	
4	0	4	DKC134-0044	Floor Protector Fwd LH Part 1 N° D32811P B35246 Selon dessin D3281 Rev.: B Job: 40952	U de M : Each
4	0	4	DKC134-0045	Floor Protector Fwd RH Part 2 N° D32812P B35247 Selon dessin D3281 Rev.: B Job: 40953	U de M : Each
4	0	4	DKC134-0046	Floor Protector Aft LH Part 3 N° D32813P B35248 Selon dessin D3281 Rev.: B Job: 40954	U de M : Each
4	0	4	DKC134-0047	Floor Protector Aft RH Part 4 N° D32814P B35249 Selon dessin D3281 Rev.: B Job: 40957	U de M : Each

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

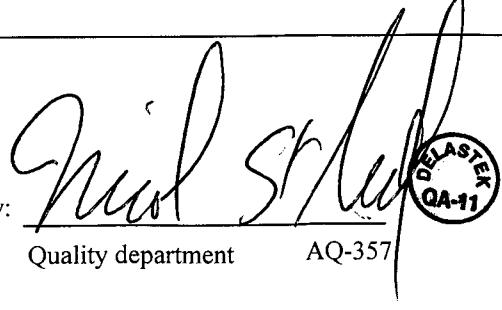
Cust.

Adm.

Quality

Ship.

Accepted by:



Neil St. Leger

Quality department

AQ-357

